

AMENDMENTS TO THE ABSTRACT:

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Please amend page 14 as follows:

ABSTRACT

The invention concerns a A method for determining a deviation of at least one regulating variable on chip removal machines with a mechanical drive for a tool and/or a workpiece, regulated by a control system, wherein the regulation comprises a plurality of values $[(C, X, Z)]$ of at least three spatial axes $[(c, x, z)]$ for the control system and for the drive, and the values $[(C, X, Z)]$ have a functional relation such as $Z = f_{bi}(C, X)$ with the axes $[(c, x, z)]$. A protocol is prepared from a plurality of control system actual values $[(C_{p,s}, X_{p,s}, Z_{p,s})]$ detected by measuring means and/or selected drive actual values $[(C_{p,a}, X_{p,a}, Z_{p,a})]$ and a control system nominal value $[($ according to $Z_{bi,s} = f_{bi}(C_{p,s}, X_{p,s})$ $)]$ and/or a drive nominal value $[($ according to $Z_{bi,a} = f_{bi}(C_{p,a}, X_{p,a})$ $)]$ is calculated at least in relation to an axis the z-axis, and a control system differential value according to $D_{z,s} = Z_{p,s} - Z_{bi,s}$ and/or a drive differential value according to $D_{z,a} = Z_{p,a} - Z_{bi,a}$ is calculated at least in relation to the axis [[z-axis]]. The invention also pertains to a A chip removal machine which implements such a method is also disclosed.